

11.212 At least two coats of orange yellow nitrate dope (Specification D-16).

11.213 Not applicable.

11.214 Not applicable.

11.215 Not applicable.

#### MISCELLANEOUS ITEMS AND REQUIREMENTS

12.1 Not applicable.

12.2 Acid Proofing.- Surfaces within at least 12 inches of storage batteries or parts further removed which are subject to acid spillage or spray shall be given two additional coats of lacquer to match regular finish.

12.3 Standard Parts.- Standard parts such as bolts, nuts, etc. shall be painted with zinc chromate primer prior to assembly wherever practicable. After assembly they shall be thoroughly coated with primer in such manner as to provide an organic fillet around all boundaries. Threads of adjustable parts such as tie rods, turnbuckles, etc., shall be lubricated and protected both before and after assembly with paralketone. Where properly protected by this material, seizure will be eliminated.

12.4 Control Cables.- Control cables shall be protected by immersion in paralketone prior to installation. After installation, they shall be lightly coated with the same material.

12.5 Tanks.-

\*\*12.51 Not applicable.

\*\*12.52 Non-integral Fuel Tank.- The inside of the fuel tank shall not be painted, but shall be filled with light oil and drained.

\*\*12.53 Oil Tank.- The interior of the oil tank requires no organic protection but shall be filled with light oil and drained. Exterior shall be protected in accordance with the general airplane schedule.

\*\*12.54 Tank Supports.- Tank supports and straps (corrosion resistant straps are not painted) shall be painted Class A-1 and also insulated from the tank by means of pads. The pads shall consist of felt enclosed in suitable fabric. The assembled pads to be thoroughly saturated in castor oil.

12.6 Tubing.-

\*\*12.61 Structural.- All structural tubing except as otherwise specified shall be protected on the interior in the same manner as the exterior. The use of steel fittings in conjunction with aluminum alloy tubing shall not be employed where suitable design can provide otherwise.

**Paint Bumpers.**— The forward face of the boat and all metal parts of the bumper shall be given additional protection of an approved preservative compound over the regular finish. The exposed surface of the bumper shall be finished with two coats of insignia blue lacquer.

11.1 Not applicable

11.2 Not applicable

11.3 **Painting Types.**— All exposed surfaces of training types shall be finished in orange yellow color of the landing gear or float which shall be finished in aluminum and otherwise specified for insignia or squadron colors.

11.4 Not applicable

11.5 Not applicable

11.6 Not applicable

11.7 Not applicable

11.8 Not applicable

**Painting of Signs and Markings.**— Shall be finished with insignia blue lacquer in such manner as to provide clear definition of functions and boundary lines. Markings shall be applied to the regular finishes specified.

12.1 **TESTING AND MARKING**

12.1 **Signs and Marking.**— Shall conform to the requirements of the latest issue of Specification SR-2.

End fittings used with open tubing shall be designed or drained so they do not form pockets for the collection of moisture.

- \*\* 12.62 Sealed Steel Structural.**- Shall be sealed by welding to exclude the entrance of moisture. After all welding operations have been completed, the interiors shall be protected in accordance with applicable specifications or instructions. When self-tapping screws are used in structural members care shall be exercised to place them in the regions of the lowest fibre stress and in carefully selected locations to prevent structural weakness and difficulties. The diameter of the hole shall bear its relation to the pipe diameter in such manner that tightness is obtained without stretching, scratching or splitting of surrounding metal.

12.621 Structures of this type shall be sandblasted and immediately thereafter protected with a shop coat of zinc chromate primer with minimum handling or contamination of the sandblasted surface.

- \*\* 12.622 Not applicable.**

12.63 Non-structural.- Tubing of this type shall receive suitable organic protection depending on size, type of material and function, whether open or closed. 2S, 3S, 52S and 53S require less protection than 17S and 24S. Closed systems of the former materials normally require no protection. Open systems of these materials shall receive a minimum of one coat of zinc chromate primer. Open systems of the latter materials shall receive two coats. All tubing shall invariably be anodized.

- \*\* 12.7 Potassium Dichromate Use of.**- A potassium dichromate container (Naval Aircraft Factory Standard Drawing 1071) shall be provided in the sump of the fuel tank. A sufficient amount of potassium dichromate shall be provided in container.

- \*\* 12.8 Beeswax and Grease on Seaplanes.**- All fastenings, strut ends, and other similar parts of seaplanes exposed to the action of sea water or spray shall receive an additional organic protection of beeswax and grease, Specification C-88. All open end struts subsequent to painting shall be dipped to a depth of at least 18 inches, drained and wiped prior to installation.

- \*\* 13. Finishes**

13.1 Extra Inspection.- Shall be required to insure that organic protection has been carefully and thoroughly applied to all interior parts below the water line. The contractors' inspectors shall be required to make a special report to this effect.

- \*\* 13.2 Exterior Finish.**- Shall be applied to floats in such manner as to provide maximum hydrodynamic and aerodynamic efficiency for assisting take-off. An especially smooth and carefully faired finish shall be provided by the proper selection of suitable water resistant coatings of approved type.

- 13.3 Not applicable.

PAINT Numbers  
2896

Yellow DuLux # 93-74084

Red (Bleeder) DuLux # 93-94124-8

White. DuLux # 508

Blue DuLux # 3380

Blue light DuLux # 3430

ALUM (Shudge Resistant ALUM) DuLux # 181-23994